

Date: Wednesday, 1/23/2008 11:33:18 AM
 User: Kim Johnston

Process Sheet

9

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FUEL SCUPER ASSEMBLY
 Job Number : 36917
 Estimate Number : 10150
 P.O. Number :
 This Issue : 1/23/2008 S.O. No. :
 Prsht Rev. : NC Part Number : D206718011
 First Issue : / / Type : LARGE FAB ASSY Drawing Number : D3270 REV B
 Previous Run : 24076 Drawing Revision : B
 Material :
 Due Date : 2/29/2008 Qty: 20 Um: Each
 Written By :
 Checked & Approved By : 08 01 23
 Comment : Est Rev: C Removed manufacturing 05-11-01

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 36917A

2.0 DC , DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPPD206-718-011 CHG001

08/04/08 08.12.12

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0 80004212 Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 80-004-2-12

Insert M107173

5.0 D3270041 Fuel Scupper Drain Assy



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3270-041

Fuel Scupper Drain Assy

2476A SX B36971A / 08/4/2

6.0 D32711 Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 D3271-1

Gasket

M107173 623971

08/4/1 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:33:18 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL SCUPER ASSEMBLY

Job Number: 36917

Part Number: D206718011

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.8 AN3H14A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

4 AN3H14A

Bolt

M184316 X

M1952280 X

M10222 248

8.0

AN960JD10L

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 AN960JD10L

Washer

M10485

9.0

MS21919DF6

Clamp



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 MS21919DF6

Clamp

15320

10X

106966 10X

10.0

MS27039140

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 MS27039-1-40

Screw

15399

11.0

NAS43DD3128

Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick: Packing Kit

Qty Part Number

Description Batch

1 NAS43DD3-128

Spacer

M101594

12/28

20

12.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

8 08/10/02 (475)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 11:33:18 AM

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FUEL SCUPER ASSEMBLY

Job Number: 36917

Part Number: D206718011

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D206-718-011

Location: _____

Rev A

08/04/02 (X)
08/04/08

14.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf

~~08-0~~

08-04-07

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

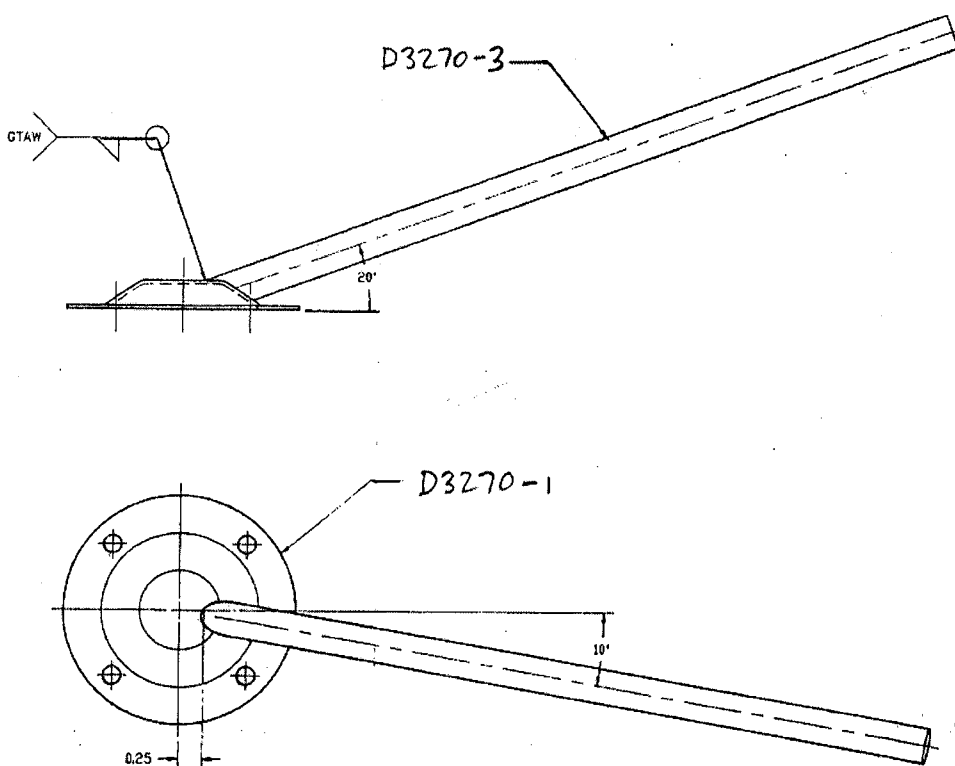
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED UP	APPROVED #	DRAWING NO. D3270	REV. B SHEET 1 OF 2
DATE 05.07.14	TITLE FUEL SCUPPER DRAIN ASSEMBLY		SCALE NTS
A	04.02.20	NEW ISSUE	
B	# 05.07.14	ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23



D3270-041 FUEL SCUPPER ASSEMBLY

- NOTES:
- 1) WELD PER DART QSI 004 USING 5356 FILLER ROD.
 - 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT GLOSS WHITE (REF. 4.3.5.1) PER QSI 005 4.3
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
 - 5) CONTOUR MAY BE ALTERED TO DOMED SHAPE AT FABRICATOR'S DISCRETION.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36917

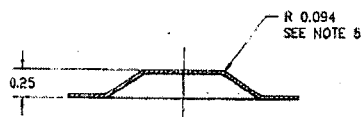
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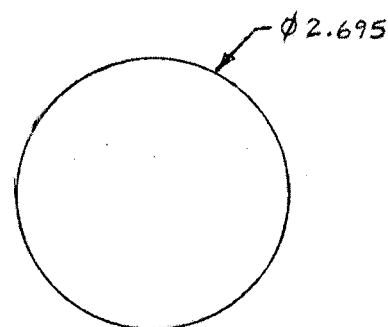
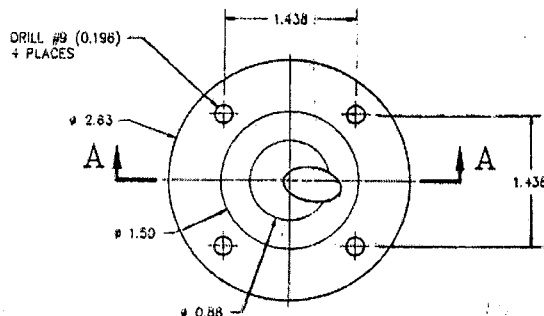


DESIGN	<i>HH</i>	DRAWN BY	<i>HH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED	<i>HH</i>	DRAWING NO.	REV. B
				D3270	SHEET 2 OF 2
DATE	05.07.14			TITLE	SCALE
				FUEL SCUPPER ASSEMBLY	NTS
A	04.02.20			NEW ISSUE	
B	HH 05.07.14			ADD D3270-1 FLAT PATTERN	

RELEASED
04.02.23



SECTION A-A

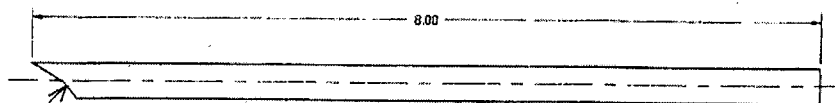


D3270-1 FLAT PATTERN



D3270-1 MOUNTING BASE

MATERIAL: 6061-T6 ALUMINUM SHEET 0.040" THICK PER QQ-A-250/11 (M6061T6S.040)



CONTOUR TO FIT
D3270-1

D3270-3 FUEL OUTLET TUBE

MATERIAL: 6061-T6 ALUMINUM TUBING 0.375" OD X 0.035" WALL (SEAMLESS)
PER MW-T-700/6 OR QQ-A-200/8 OR QQ-A-225/8
(M6061T6T0.375W0.035)

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CUSTOMER RETURN

Initiator: Jean Kerr
 Company: AERO Product Component.
CAPR001

Date: Sept 11/08
 Invoice # 7304
 Order Entry # 6845

Phone No. _____

Attach Copy of DHS Return Authorization # 461

Reason for return: Duplicate order previously shipped on
P/O 8608164 DHS Error (placed 2 orders)

Receiving:

Date Received: 08/09/11 Freight Company: UPS 126645N1 689561 9188 Prepaid Collect

#	Part #	Batch #	Description	Distribute to QC	
1	<u>D206-718-011</u>	<u>36917</u>	<u>FUEL Scupper.</u>	Advise QA	Date:

Condition of packaging: _____ Photograph required: yes no

Paperwork attached: P/S _____ Invoice _____ ARC _____ Docs _____ Other _____

QC:

Quarantine: _____ Location: _____ Condition of Part: good

Inspect: _____ Initial: [Signature]

#	Part #	Batch #	QC Comments	QC Approval		Scrap
1	<u>D206-718-011</u>	<u>B36917</u>	<u>Return to stock as per W/O</u>	Initial <u>[Signature]</u>	W/O # <u>42098</u>	

QA Coordinator:

Advise GM as to findings: _____ Initial: _____ Date: _____

Comments: _____

REFERENCE ONLY

Issue credit: yes no

GM Approval: _____ Date: _____

Invoice Amount: _____
 Less Replacement: _____
 Restock Fee: _____
 Freight: _____
 Net Credit: _____
 DHS ☐ Customer ☐

QA: Enter into Q-Pulse with reason for return & File original. Signed: _____ Date: _____

Copy of Customer Return to stay with work orders and another copy to be filed with customer credit